

Work Order ID 111181

January-09-14 12:39:07 PM

\*111181\*

Page 1

Item ID: D4635-043

Revision ID:

Item Name: Aft Ceiling Panel Assembly, LH

Start Date: 09/01/2014 Start Qty: 1.00

Required Date: 24/01/2014 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: *MA*

Date: 14-01-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4635

PB2 DEL *OK**Rev E*DAS  
27  
9-89*per 9-14-89*

100

0.00

\*1.00\*

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

*1**DL*  
*14/01/22*

110

0.00

\*1.10\*

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg D4635-043

2-Install speaker

3- Install Air valve

4-Install Wiring Harness

5-Install wiring harness

*1**DL*  
*14/01/22*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 111181

January-09-14 12:39:07 PM

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Page 2

Item ID: D4635-043 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Aft Ceiling Panel Assembly, LH  
Start Date: 09/01/2014 Start Qty: 1.00 \*1\* Cust Item ID:  
Required Date: 24/01/2014 Req'd Qty: 1.00 \*1\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00 27 0.00 14/1/23							1 Inspect as per Dwg PE1
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00 0.00							thermoforming MJS
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							MJS 14-01-23 mf

POSITIVE RECALL  
EFFECTIVE 1/14/23 AUTH h  
RELEASED 5 DATE 1/14/24

Release Dwg as  
Per Rev E  
DAS  
27  
9-89  
14-1-23

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

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# Picklist Print

Tuesday, January 21, 2014 1:49:52 PM

Page 1

Work Order ID: 111181

Parent Item: D4635-043

Parent Item Name: Aft Ceiling Panel Assembly, LH

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL  
DL IPP Rev C Dwg. Update 13/07/09 DL verf:DD IPP  
Rev D Dwg Update 14/01/20 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS24693-DB50 SCREW-DB51		Purchased	No				Each	100.0000		4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST300		100							
				127924		100							
D4635-143		Manufactured	No			100	Each	1.0000	1	1			
Aft Ceiling Replacement Panel Assembly, LH				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		1							
				111206		1							
D4646-1		Manufactured	No			100	Each	84.0000	1	1			
Plenum Cap Assembly				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST116		84							
				103832		66							
				92968		6							
				95779		12							
D4652-1		Manufactured	No			100	Each	203.0000	1	1			
Air Valve, 1.16 Id Disk Type				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		12							
				111316		12							
				ST099		191							
				111311		191							



# Picklist Print

Tuesday, January 21, 2014 1:49:52 PM

Page 2

Work Order ID: 111181

Parent Item: D4635-043

Parent Item Name: Aft Ceiling Panel Assembly, LH

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

D4655-1  
Speaker

Manufactured No

100 Each 90.0000

1 1

Location

Loc Qty

Loc Code

ST478

48

103939

48

ST483

42

93061

42

D4708-9

Lanyard

Manufactured No

100 Each 55.0000

1 1

Location

Loc Qty

Loc Code

ST119

55

111242

49

93919

6

D4728-045

LH Cabin Speaker #3

Manufactured No

100 Each 1.0000

1 1

Location

Loc Qty

Loc Code

ST121

1

96243

1

D4728-061

Cabin Lights Control Relay

Manufactured No

100 Each 1.0000

1 1

Location

Loc Qty

Loc Code

ST121

1

96170

1

D4743-1

Speaker Grill

Manufactured No

100 Each 30.0000

1 1

Location

Loc Qty

Loc Code

ST122

30

111220

30

Tuesday, January 21, 2014 1:49:52 PM

Shop Packet Print

Page 2

# Picklist Print

Tuesday, January 21, 2014 1:49:52 PM

Page 3

Work Order ID: 111181

Parent Item: D4635-043

Parent Item Name: Aft Ceiling Panel Assembly, LH

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

MS21044-N08 Purchased No

100 Each 265.0000 4 4

Nut

Location	Loc Qty	Loc Code
ST315	265	
123741	115	
m127813	150	

MS21919-WDG8 Purchased No

100 Each 82.0000 3 3

Clamp

Location	Loc Qty	Loc Code
ST322	82	
m127305	12	
m127831	40	
m127916	30	

NAS1149DN832J Purchased No

100 Each 3,348.0000 4 4

Washer

Location	Loc Qty	Loc Code
ST293	1000	
M127813	1000	
st510	376	
124555	376	
ST510a	1972	
M126319	972	
M127255	1000	

PLT1.5M-M Purchased No

100 Each 1,008.0000 3 3

Tie Wrap

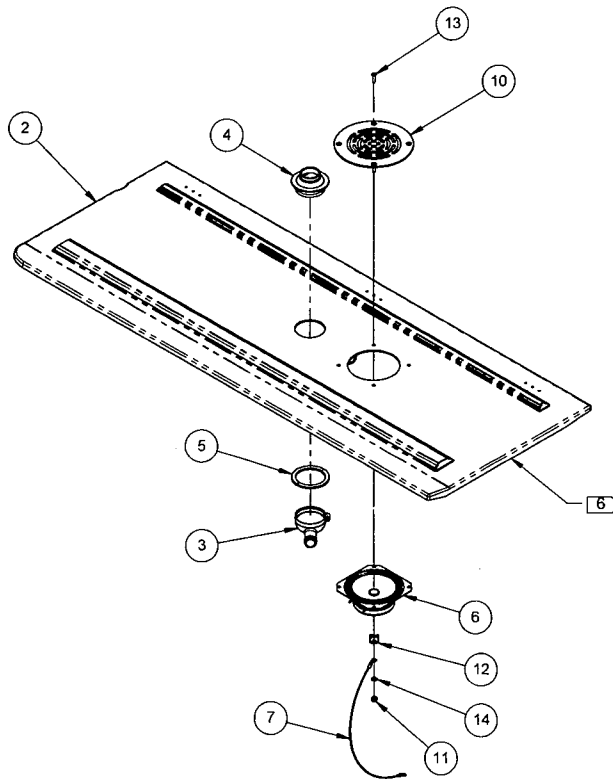
Location	Loc Qty	Loc Code
ST389	1008	
124363	8	
m126551	1000	

Tuesday, January 21, 2014 1:49:52 PM

Shop Packet Print

Page 3





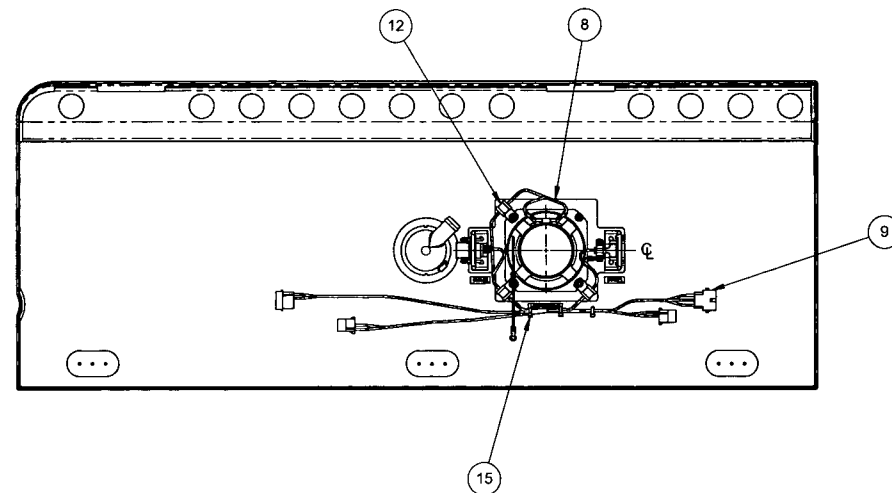
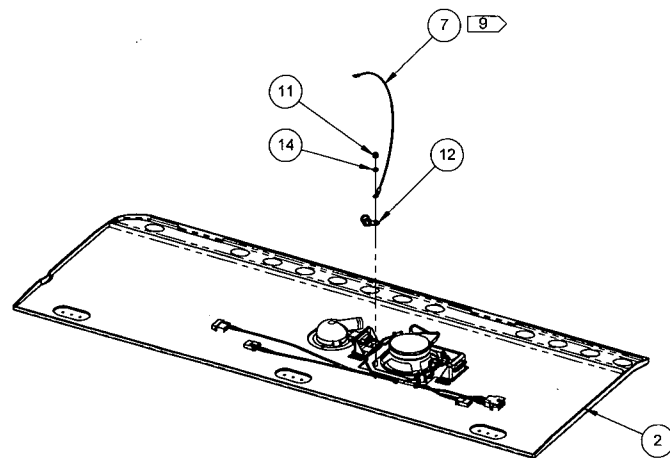
**D4635-043 LH, AFT CEILING PANEL ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 4.47 lbs
- 8) INSTALL D4728-045/-061 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO  $\varnothing 0.196$  BOTH ENDS

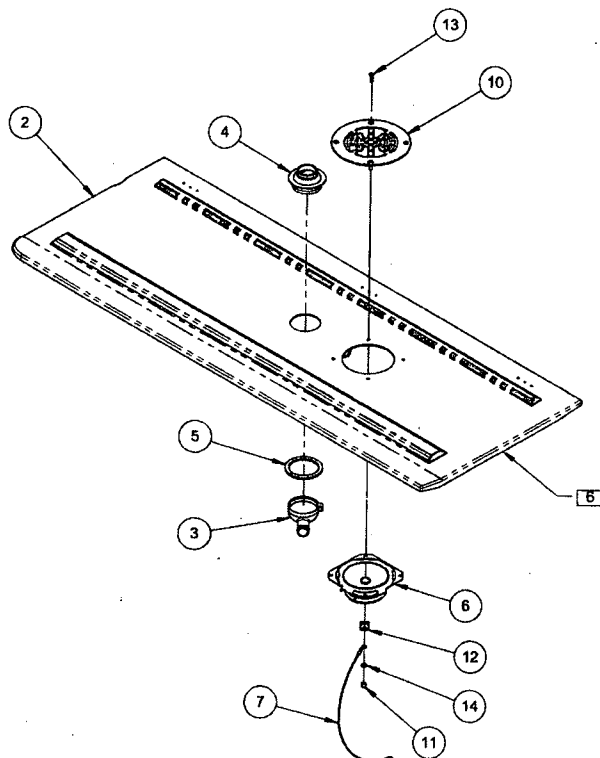
ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4635-043	LH, AFT CEILING PANEL ASSY
2	1	D4635-143 ✓	LH, AFT CEILING REPLACEMENT PANEL ASSY
3	1	D4646-1 ✓	PLENUM CAP ASSEMBLY
4	1	D4652-1 ✓	AIR VALVE
5	1	D4652-3 (REF) ✓	MOUNTING NUT (PART OF D4652-1)
6	1	D4655-1 ✓	SPEAKER
7	1	D4708-9 ✓	LANYARD
8	1	D4728-045	LH SPEAKER #3 HARNESS ASSEMBLY
9	1	D4728-061	CABIN LIGHTS CONTROL RELAY HARNESS ASSEMBLY
10	1	D4743-1	SPEAKER GRILL
11	4	MS21044-N08	NUT
12	3	MS21919WDG8	CLAMP
13	4	MS24693-BB50	SCREW
14	4	NAS1149DN832J	WASHER
15	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DL	DRAWING NO. <b>D4635</b>	REV. PE1
MFG. APPR.			SHEET 5 OF 18
APPROVED		TITLE <b>OUTBOARD CEILING PANELS</b>	SCALE NTS
DE APPR.		COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	14.01.09		



**D4635-043 LH. AFT CEILING PANEL ASSY**  
AUXILIARY VIEW

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. <b>D4635</b>
MFG. APPR.		REV. PE1 SHEET 6 OF 18
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DATE	14.01.09	



**D4635-043 LH, AFT CEILING PANEL ASSY**

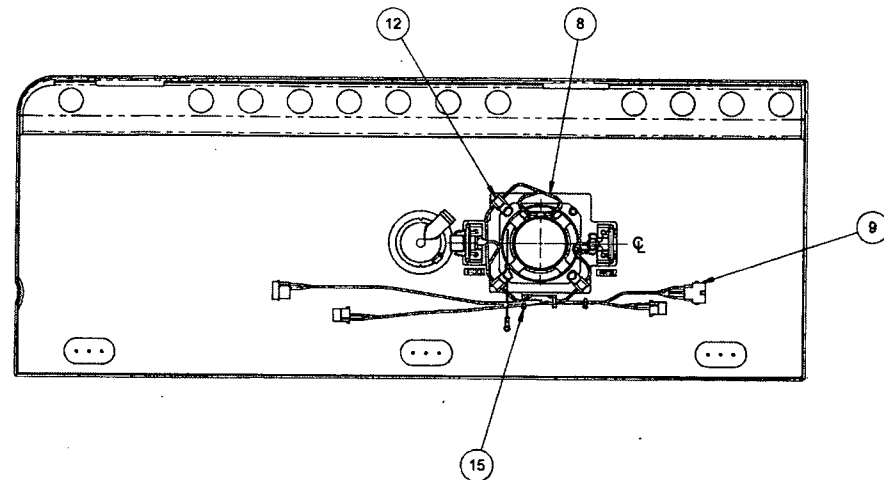
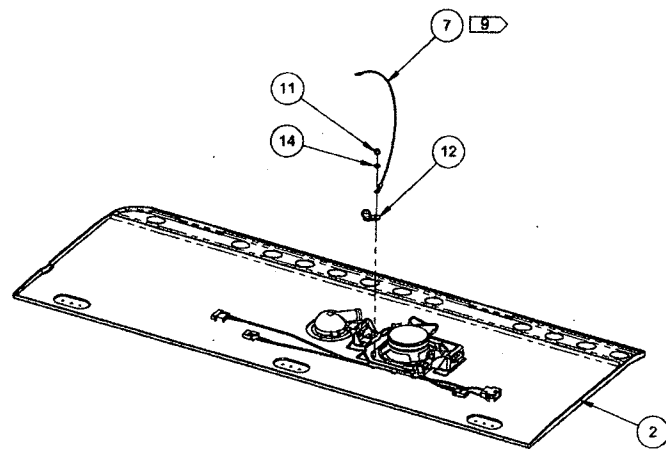
**NOTES:**

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- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 5.0 lbs
- 8) INSTALL D4728-045/-061 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO Ø0.196 BOTH ENDS

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4635-043	LH, AFT CEILING PANEL ASSY
2	1	D4635-143	LH, AFT CEILING REPLACEMENT PANEL ASSY
3	1	D4646-1	PLENUM CAP ASSEMBLY
4	1	D4652-1	AIR VALVE
5	1	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
6	1	D4655-1	SPEAKER
7	1	D4708-9	LANYARD
8	1	D4728-045	LH SPEAKER #3 HARNESS ASSEMBLY
9	1	D4728-061	CABIN LIGHTS CONTROL RELAY HARNESS ASSEMBLY
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11	4	MS21044-N08	NUT
12	3	MS21919WDG8	CLAMP
13	4	MS24693-BB51	SCREW
14	4	NAS1149DN832J	WASHER
15	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. E
MFG. APPR.	PC	<b>D4635</b>	SHEET 5 OF 18
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	<b>OUTBOARD CEILING PANELS</b>	NTS
DATE	14.01.09	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





**D4635-043 LH AFT CEILING PANEL ASSY**  
AUXILIARY VIEW

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.	DC	<b>D4635</b>	SHEET 6 OF 18
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	<b>OUTBOARD CEILING PANELS</b>	NTS
DATE	14.01.09	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

